Each

Dart Aerospace Ltd. Wednesday, 5/31/2006 7:36:17 AM Date: Kim Johnston User: **Process Sheet** : BRACKET ASSEMBLY : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 27284 : 10334 **Estimate Number** · NIA : D2804042 Part Number P.O. Number S.O. No. : NIA : D2804 REV B **Drawing Number** : 5/31/2006 This Issue : N/A. : NC **Project Number** Prsht Rev. : NIA : R & D SM/MED FAB : B **Drawing Revision** First Issue : NIM : 26252 Material **Previous Run** 12 Um: : 6/20/2006 **Due Date** Qty: Written By Checked & Approved By KJ/JLM Comment : Est F **Additional Product** Job Number: Seq. #: Description: **Machine Or Operation:** D28042 STA 155 Bracket 1.0 Total: 12.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit STA 155 Bracket Pick: **Qty Part Number** Description D2804-2 Bracket 2.0 D28052 Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Stop Pick: Batch iB 24620 **Qty Part Number** Description D2805-2 Stop D2809 Bushing

Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing Pick:

Qty

1

Part Number D2809

Description

Bushing

FF 06.06.14

4.0 SMALL FAB



Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-2 into arm as per Dwg D2804



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W/O:		W/O: WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
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NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annual	Approval QC Inspector			
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr				
		75									

Part No:	PAR #:	Fault Category: N	NCR:	Yes	No	DQA:	Date:	
NOTE: Date & initial all entries				QA: i	N/C-C	losed:	Date:	

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Wednesday, 5/31/2006 7:36:17 AM Date: Kim Johnston User: **Process Sheet Drawing Name: BRACKET ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Part Number: D2804042 Job Number: 27284 Job Number: Seq. #: Machine Or Operation: Description: INSPECT WORK TO CURRENT STEP 5.0 QC5 311 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING **Comment: POWDER COATING** DL Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 06.06.14 12 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 8.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 12 06.06.14 Press Fit D2809 as per Dwg D2804 Bolt 9.0 AN3C16A Comment: Qtv.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s) Bolt Pick: Qty Part Number Description Batch 64 2 AN3C16A Bolt 06.06.14 MS210433 10.0 Nut Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s) Nut Pick: Description Batch **Qty Part Number** FF 06.06.14 MS21043-3 Nut NAS1515H3 11.0 4.0000 Each(s)/Unit Total: 48.0000 Each(s) Comment: Qty.: Washer Pick: Qty Part Number Description Batch 4 NAS1515H3 Washer LPS-3 A/R Corrosion Spray Page 2

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W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
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NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR)			
		Description of NC Corrective Action Section B Ve			Verification	Approval	A	
DATE	STEP	SIEP Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspector
								

Part No:	PAR #:	Fault Category:N	NCR:	Yes No bQA:	Date: 00/06/16
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

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Wednesday, 5/31/2006 7:36:18 AM Date: User: Kim Johnston **Process Sheet Drawing Name: BRACKET ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Part Number: D2804042 Job Number: 27284 Job Number: **Description:** Seq. #: **Machine Or Operation:** SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 12.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 12 2-Assemble as per Dwg D2804. INSPECT WORK TO CURRENT STEP 13.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 PACKAGING 1 14.0 Comment: PACKAGING RESOURCE #1 Identify and Stoc Location: DOCUMENT CONTROL DC 15.0 Comment: DOCUMENT CONTROL Inspection Level 21 a de de. 16 Job Completion

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	WORK ORDER CI	HANGES				
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
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	STEP		STEP PROCEDURE CHANGE By			STEP PROCEDURE CHANGE By Date Qty Mfg / Design

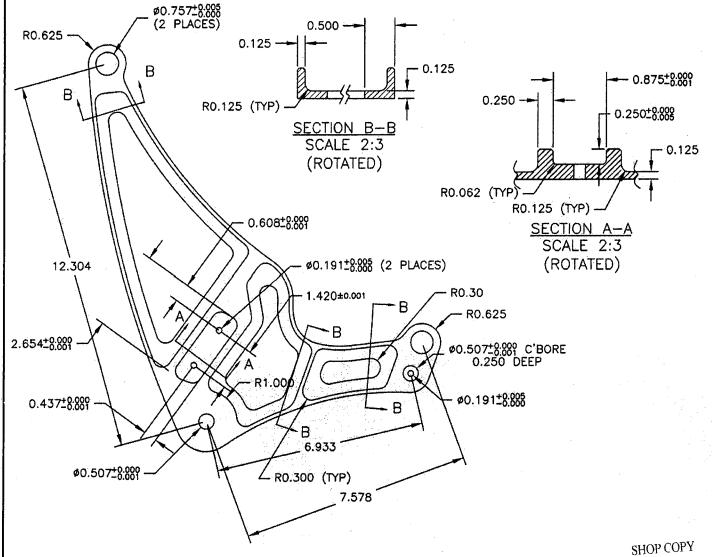
NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
		Description of NC	Description of NC Corrective Action Section B				Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	N/C C	losed:	Date:



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DESIG	CP	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
CHECK	ED	APPROVED A	DRAWING NO.	REV. B
	91	1	D2804	SHEET 1 OF 2
DATE			TITLE	SCALE
04.1	1.22		STA 155 BRACKET	1:3
Α		00.11.07	NEW ISSUE	· ·
В		04.11.22	ADD CUTOUTS & -043/-044	

RELEASED 05.03.11



RETURN TO ENGINEERING

WITHOUT NOTICE

WORK ORDER

D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

UNCONTROLLED COPY SUBJECT TO AMENDMENT 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"

2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK

3) DEBURR TO LEAVE RO.030 - 0.063 ON ALL EDGES

4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

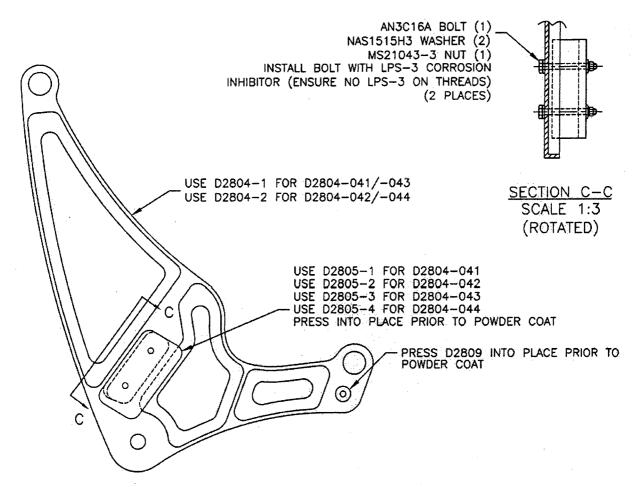
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY	DART AEROS HAWKESBURY, ONT.	
CHECKED #	APPROVED #	drawing no. D2804	REV. B SHEET 2 OF 2
DATE		TITLE	SCALE
04.11.22		STA 155 BRACKET	1:3



SHOP COPY

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ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDE NO. 2728

D2804-041/-043 BRACKET ASS'Y (SHOWN). D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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